



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-3

Job Sheet 175960



Part No: D3319-3

Job Qty: 12 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	5/19/18	5/19/18	0.00	0.00	Start Up Waterjet		SC 18/04/15
100	Waterjet	6 pcs	5/19/18	5/19/18	0.00	1.40	Waterjet1		SC 18/04/15
110	QC	6 pcs	5/19/18	5/19/18	0.00	0.00	QC2 Waterjet-2		SC 18/04/15
120	QC	6 pcs	5/19/18	5/19/18	0.00	0.00	QC8-2		38
140	Brake NC	12 pcs	5/19/18	5/19/18	0.12	0.84	Brake NC 1		38 SD
150	QC	12 pcs	5/19/18	5/19/18	0.00	0.00	QC5		23
160	Autoweld 1	12 pcs	5/19/18	5/19/18	0.00	3.82	Automated welding		100
170	QC	12 pcs	5/19/18	5/19/18	0.00	0.00	QC10		10 18-05-04
180	QC	12 pcs	5/19/18	5/19/18	0.00	0.00	QC5		10 18-05-04
190	SprayPaint	12 pcs	5/21/18	5/21/18	0.00	1.20	Spray Paint		AS 18-05-04
200	QC	12 pcs	5/21/18	5/21/18	0.00	0.00	QC3		10 18-05-04
210	Packaging	12 pcs	5/21/18	5/21/18	0.00	0.00	Packaging3-1		5/26/18
220	QC21-SA	12 Ea	5/21/18	5/21/18	0.00	0.00	QC21		6 18-05-04

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 138854

210 - Identify on inside surface using a permanent fine point marker with the following:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	19.5000 sf (3.25 ea)	90-Start up Operation	5055009

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	20	192	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0.192	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Suspended ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																				
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Date: _____		Step #: _____		(QSI042) Approval Completed By _____ Hand / Supervisor Approval Verification _____ QA Coordinator Approval _____ DART Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K4A 1K7 CANADA TEL: 1 613 632-8200 Email: sales@dartaero.com www.dartaerospace.com																																																																			
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2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499	0,501
3	Wearplate	0.316inches ± 0.010	0.326 0.306	0,316
4	Wearplate	0.607inches ± 0.010	0.617 0.597	0,609
5	Wearplate	2.940inches ± 0.030	2.970 2.910	2,943
6	Wearplate	2.690inches ± 0.030	2.720 2.660	2,692
7	Wearplate	3.527inches ± 0.010	3.537 3.517	3,529
8	Wearplate	4.520inches ± 0.030	4.550 4.490	4,522
9	Wearplate	5.063inches ± 0.010	5.073 5.053	5,064
10	Wearplate	6.160inches ± 0.030	6.190 6.130	6,165
11	Wearplate	0.600inches ± 0.030	0.630 0.570	0,606
12	Wearplate	8.690inches ± 0.010	8.700 8.680	8,694
13	Wearplate	30.790inches ± 0.010	30.800 30.780	30,79
14	Wearplate	52.880inches ± 0.030	52.910 52.850	52,88
15	Wearplate	62.770inches ± 0.010	62.780 62.760	62,77
16	Wearplate	74.420inches ± 0.010	74.430 74.410	74,42
17	Wearplate	75.520inches ± 0.030	75.550 75.490	75,52
18	Wearplate	0.050inches ± 0.010	0.060 0.040	0,048

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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